

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002431**Date Inspected:** 13-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Changxing Island**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Skin plates**Summary of Items Observed:**

CWI name: Wang Cheng Jun, Yang Yi Heng

"Push down" Heat straightening on skin plate (Tower bay#1 and bay #2): Caltrans Quality Assurance Inspector (QAI) observed few Zhenhua Port Machinery Co (ZPMC) heat straightening operators performed heat straightening with ZPMC Heat Straightening Report (HSR) on plate numbered PSA294, P143, P853W and P853E. The heating temperature is maximum 650 C (1200 F) and cool in still air. All the plates have been monitored and recorded and inspected by ZPMC QC within from 0.5mm to 1mm off set (Caltrans requirement Max 3mm) after heat straightening to cooled to ambient temperature. Based on Caltrans QAI observation, no discrepancies were noted.

Magnetic particle testing (MT) on splice welds (Tower bay#1 and bay #2): Two ZPMC MT technicians performed QC 25% MT testing on three splice weld of skin plates. The test splice weld numbered # ESD1-SA77A/E-33A, ESD1-SA294A/G-1A and SSD1-SA17A/G-17A. The grease, rust, scale and other moisture have been removed by ZPMC workers on both side 200mm of splice weld areas prior MT testing. The power source of MT testing is used electromagnetic yoke with Alternating Current (AC) made by Magnaflux. The detection media is used dry red ferromagnetic particles. The technique uses dry particles that are applied while the magnetizing force is on. A field indicator used to check the magnetic field direction and to ensure adequate field strength during MT testing. The 25% MT testing of three splice weld areas appeared to be in compliance with the requirements of AWS D1.5 (2002) and Caltrans contract documents.

Submerged Arc Welding (SAW) process on skin plate (Tower bay#1 and bay#2): Caltrans QAI observed four ZPMC welding operators performed semi-automatic SAW on the splice weld of ASTM 709 345 skin plate numbered P1028A to P1028B with 65mm wall thickness, weld# SSD1-SA15A/F-32A, skin plated numbered

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P1309 to P1301 to P16 to P837 to P1302 with 80mm wall thickness, weld# SSD1-SA178C/D-14A-14B, SSD1-SA178C/D-10-12 and SSD1-SA178C/D-4A-4B. The weld designed is a double -V-groove with welding conducted in the in flat position (1G) with proper 4.8mm diameter wire feed electrode JW3 and flux/J1-B, made by China Company and completed with approximate five pass. The parameters used for SAW welding of splice weld was conducted in accordance with Caltrans approved WPS-B-T-2221-B-U3. The semi-automatic SAW was monitored and recorded by ABF Certified Welding Inspector (CWI) Miss. Xie Yan Mr. Wei Jiam Bo. Based on Caltrans QAI observations, no discrepancies were noted.

Flux Cored Arc Welding (FCAW) welding process on skin plate (Tower Bay#2): Caltrans QAI observed a welder was performing FCAW process on splice weld of skin plate numbered P326S to P329S with 65mm wall thickness, weld# SSD1-SA159F/J-7A. The parameters used for FCAW process of splice weld was conducted in accordance with Caltrans approved WPS-B-T-2231-B-U3-F. The electrode being used is super cored 71.H with 0.14mm diameter made by China Company. The FCAW process was monitored and recorded by ZPMC QC Inspector and ABF CWI. Base on Caltrans observation, no discrepancies were noted

Summary of Conversations:

As Note within the report above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Wahbeh Mazen (818)292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Pau,Wai	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
